

Date: Tuesday, 10/02/2009 2:43:15 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MECHANICAL GROUND HANDLING WHEEL KIT
Job Number : 45681A	
Estimate Number : 12136	
P.O. Number :	Part Number : D206731041
This Issue : 10/02/2009 S.O. No. :	Drawing Number : DSK 093 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 44441A	Material :
Written By :	Due Date : 28/02/2009 Qty: 1 Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : : est rev. A 01.02.01 new issue EC Est Rev:B As per Rev B 07-02-13 JLM est rev C 07.05.14 rev C IIN Ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description
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1.0	D33355	spring
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 pick:
 qty Part Number Description batch
 1 D3335-5 spring

2.0	D3353041	Lug Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 LUG ARM WELDMENT
 Batch: _____

3.0	D3354041	Left Arm Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 pick:
 qty Part Number Description batch
 1 D3354-041 Left Arm Weldment

4.0	D3354043	Right Arm Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 RIGHT ARM WELDMENT
 batch: _____

Deleted
Lost at

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D33561	Pin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	D3356-1	pin	

6.0	D3397041	Wheel Assembly
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	D3397-041	Wheel ass'y	

7.0	113800	GREASE FITTING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	113-800	GREASE FITTING	

8.0	656051	flat washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	656-051	flat washer	

9.0	663079	Inventory
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	663-079	Lock washer	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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10.0	AN523A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN5-23A	Bolt	

11.0	AN960JD516	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	AN960JD516	Washer	

12.0	CP21	1/8" Cotter Pin 2" long
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
2	CP21	1/8" Cotter Pin 2" long	

13.0	MS21042L5	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	MS21042L5	Nut	

14.0	SNF34	SLOTTED NUT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	SNF-34	SLOTTED NUT	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D206731041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

TP2

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	Part Number	Description	batch
1	TP-2	Spring pin	_____

16.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

qty	Part Number	Description	batch
1	TP-134	Spring pin	_____

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per dwg DSK 093

2-Grease fitting 113-800, apply LPS C30316 on all parts areas not protected by paint or grease.

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

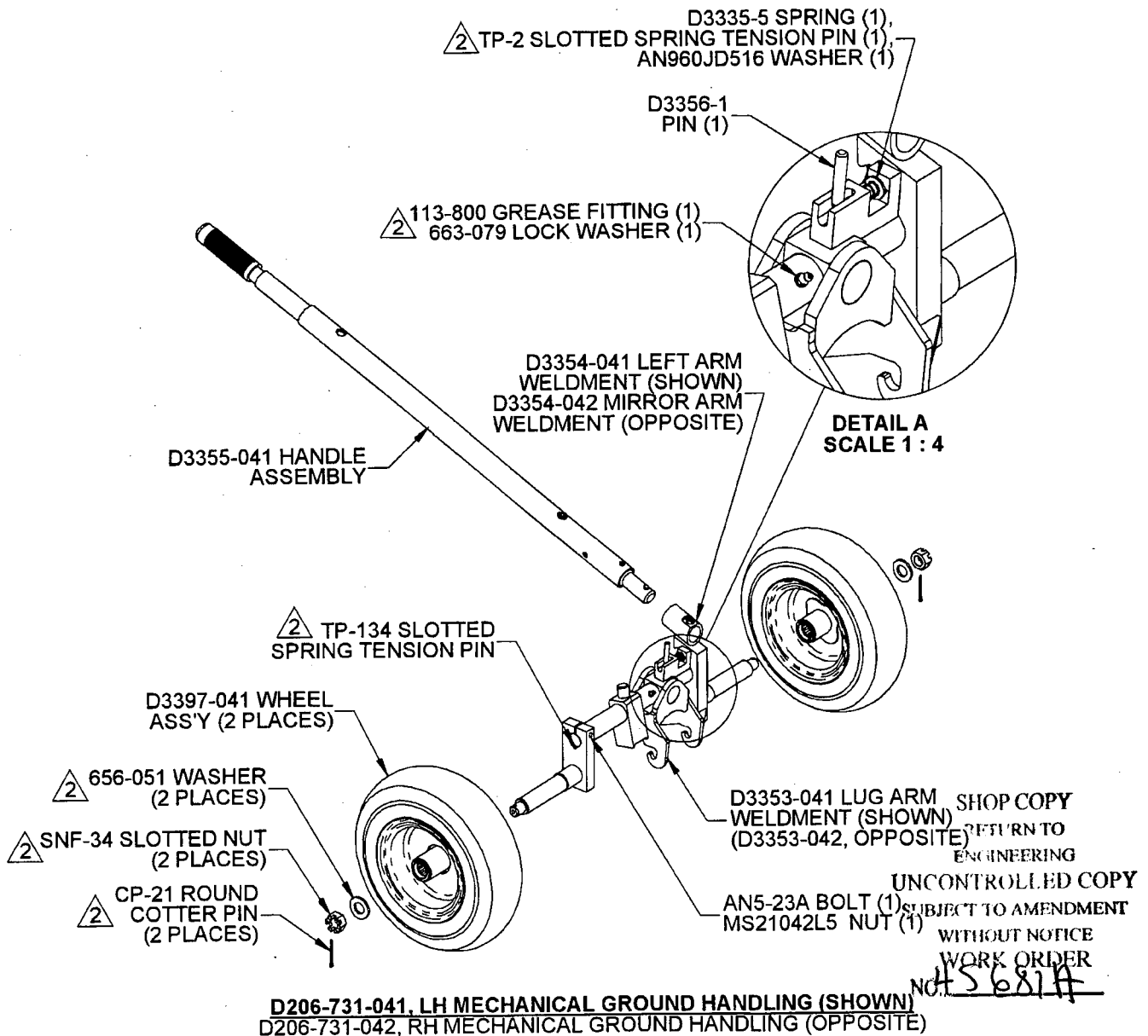
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.02.05

DESIGN R#	DRAWN BY J	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED AHH	APPROVED AHH	DRAWING NO. DSK 093	REV. B SHEET 1 OF 1
DATE 07.02.02	TITLE MECH. GROUND HANDLING	SCALE 1:10	
REV	DATE	DESCRIPTION	
A	05.02.10	NEW ISSUE	
B	07.02.02	REDRAWN	

**NOTE:**

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.
- 2) SUPPLIER: SPAENAU.

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